

Date: Thursday, 11/29/2007 11:10:25 AM
 User: Kim Johnston

Process Sheet

52

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L AFT X-TUBE
 Job Number : 36059
 Estimate Number : 10973
 P.O. Number :
 This Issue : 11/29/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D206667203
 First Issue : 1 / Type : LANDING GEAR Drawing Number : D206-667-243 REV B
 Previous Run : 36058 Drawing Revision : B
 Material :
 Due Date : 12/24/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 11/29
 Comment : Est Rev F 05.09.01 Add holes for compatibility with Bell
 Skid tubes KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

J.F. 08.01.28

2.0 D6004115 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube B32305

Check OD = 2.500"; ID = 1.800"

J.F. 07/12/07

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

J.F. 07/12/07

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:10:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243
Inside of Cuff(Donot engrave on outside of tube)

J.F. 07/12/07 ①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/07 ①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SF 07/12/07

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

AWM 07-12-10

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-12-10

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 7-12-10

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg. D206-667-243 using CNC bender program 206L-AF and Folio FT_____ EL 7-12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 206L AFT X-TUBE

Job Number: 36059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

SR
7-12-11

AWM
07-12-12

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 07-12-12

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S. Alzly

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-203 PAR #: N/A Fault Category: Prod / Landing gear NCR: Yes No DQA: 12 Date: 08/02/14
 QA: N/C Closed: 12 Date: 08/02/14

NCR: <u>36059</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/14	# B.	when Drilling holes for D2813 the operator touched the opert side (inside) of the cage causing a small dimple from the Drill bit.	<u>PS1042</u> <u>07/12/13</u> <u>PS1042</u>	DRILL AFFECTED SIDE TO LOOK LIKE OPPOSITE SIDE, ie. 3 bolt holes + 6 RIVET HOLES. REF. DSI 9346 Rev.F (ATTACHED).	<u>SR</u> <u>7-12-13</u>	<u>08/02/02</u>	<u>07.12.13</u> <u>PS</u> <u>PS1042</u>	<u>07/12/14</u>
		* DO NOT PASS Step 19. without Eng sign off *						

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 5299

C207112/17 ①

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

Ce 4/2/17 ①

19.0

QC6

DIMENSIONAL CHECK



Do Not Pass This Step
OK 08.01.09

POSITIVE
RECALL

Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

08/01/02

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

RT 08-01-09

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

08/01/02

22.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2873-045

Nut Plate

34077

RT 08 01 -08

POSITIVE RECALL

EFFECTIVE

07/12/04

AUTH LL

RELEASED LL

DATE 07.01.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206L AFT X-TUBE

Job Number: 36059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

33422

RT 08-01-08

24.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

105057

RT 08-01-08

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

RT 08 01 08

26.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

35900

RT 08 01 18

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1

Support

34063

RT 08-01-18

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

105066

RT 08-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

RT 00-01-18

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 of 13 (4)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105408 3x M104679 1x

PU

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M105940

PU

34.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt M104746

PU

35.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

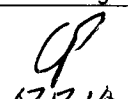
Qty Part number

Description Batch

M105408

PU

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.12.18	38	ADD DSI 9346 Rev.G, PROVIDED BY ENG.				 07.12.18 08/042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN5-32A

Bolt

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer M106167

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location: C

PPP Rev: C



NEED DSI 9346 REV. G

FROM ENG.

SEE W/6 CHG

ADDED

08.02.04

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U POSITIVE RECALL

EFFECTIVE 07.12.18

AUTH CP

RELEASED CP

DATE 08.02.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 36059
Description: Crosstube Assembly	Part Number: D206-667-243
Inspection Dwg: D206-667-243 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

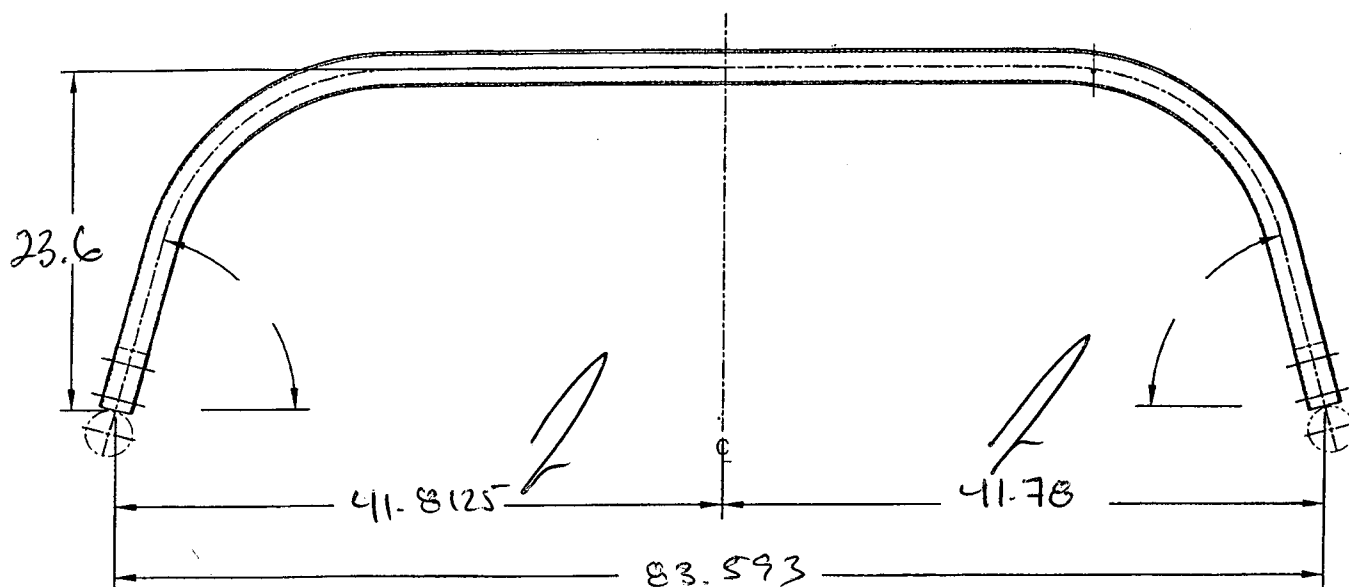
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.495"	✓		
	2.018	+0.005/-0.000	2.023"	✓		
	2.079	+0.005/-0.000	2.084"	✓		
	2.145	+0.005/-0.000	2.150"	✓		
	2.209	+0.005/-0.000	2.214"	✓		
	2.287	+0.005/-0.000	2.291"	✓		
	2.363	+0.005/-0.000	2.365"	✓		
	2.433	+0.005/-0.000	2.437"	✓		
	0.200	+/-0.010	2.00"	✓		
	0.500 x 30°	+/-0.010	500x30°	✓		
	R0.063	+/-0.010	R0.063"	✓		
	R0.500	+/-0.010	R0.500"	✓		
	4.438	+/-0.030	4.451"	✓		
SIDE B	104.91	+/-0.020	104.910"	✓		
	2.490	+0.005/-0.000	2.494"	✓		
	2.018	+0.005/-0.000	2.023"	✓		
	2.079	+0.005/-0.000	2.084"	✓		
	2.145	+0.005/-0.000	2.150"	✓		
	2.209	+0.005/-0.000	2.214"	✓		
	2.287	+0.005/-0.000	2.290"	✓		
	2.363	+0.005/-0.000	2.365"	✓		
	2.433	+0.005/-0.000	2.436"	✓		
	0.200	+/-0.010	2.00"	✓		
	0.500 x 30°	+/-0.010	500x30°	✓		
	R0.063	+/-0.010	R0.063"	✓		
	R0.500	+/-0.010	R0.500"	✓		
	4.438	+/-0.030	4.453"	✓		

Measured by: J.F.	Audited by: J.F.	Prototype Approval:	N/A
Date: 07/12/07	Date: 07/12/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	

DART AEROSPACE LTD		Work Order:	36059
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	07-12-10
Date	07-12-10

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-07-26

UNDER REVIEW

06-08-10 RH

12 draw detail F

RH
07.05.02

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

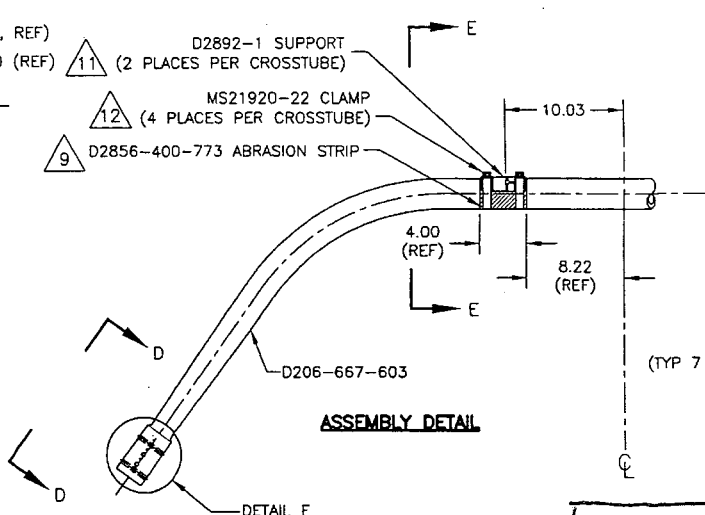
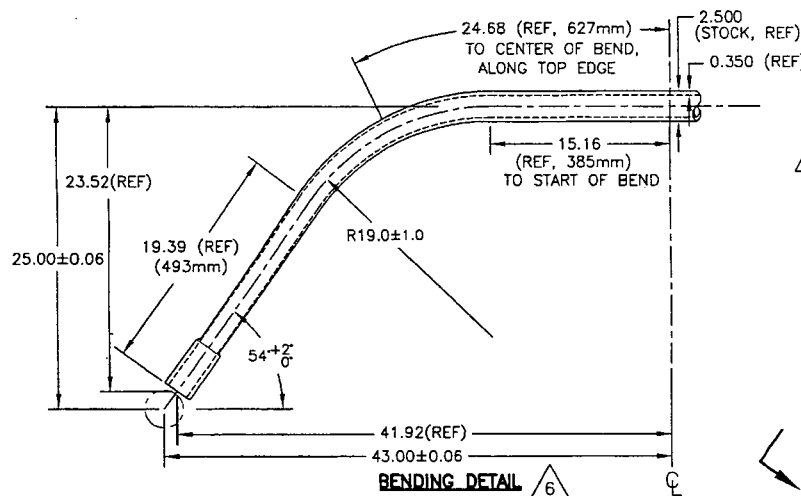
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36059

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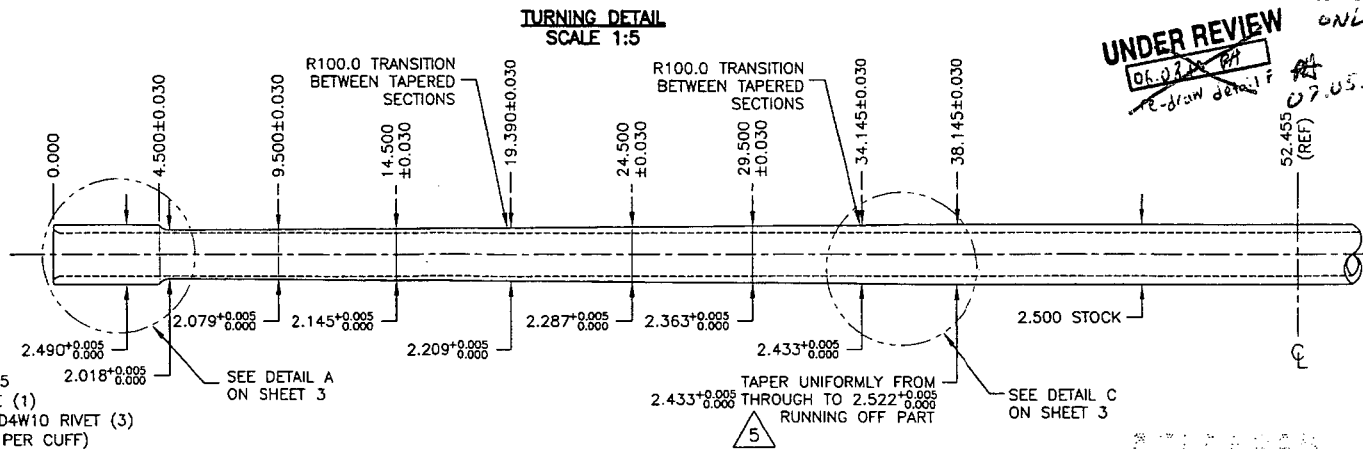
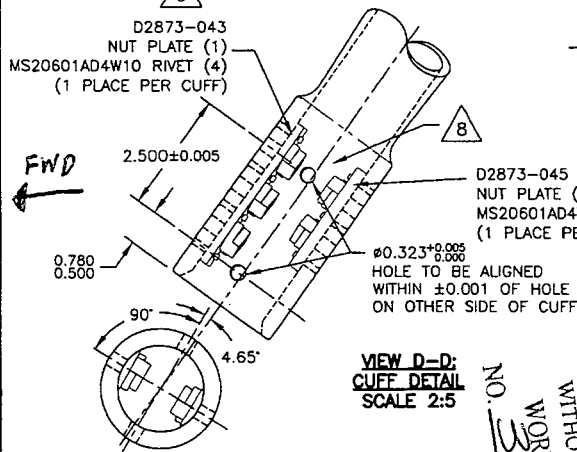
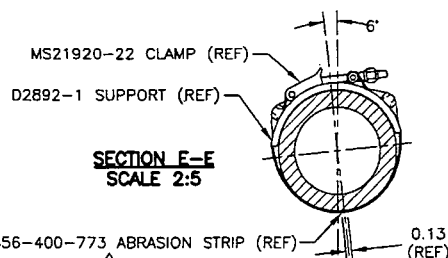
△ B $\varnothing 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001 OF HOLE ON OTHER SIDE OF CUFF

PILOT $\varnothing 0.128$
C'SINK $\varnothing 0.225 \times 100'$
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

DETAIL F
SCALE 2:5

UNDER REVIEW
05.07.26 PH
re-draw detail F



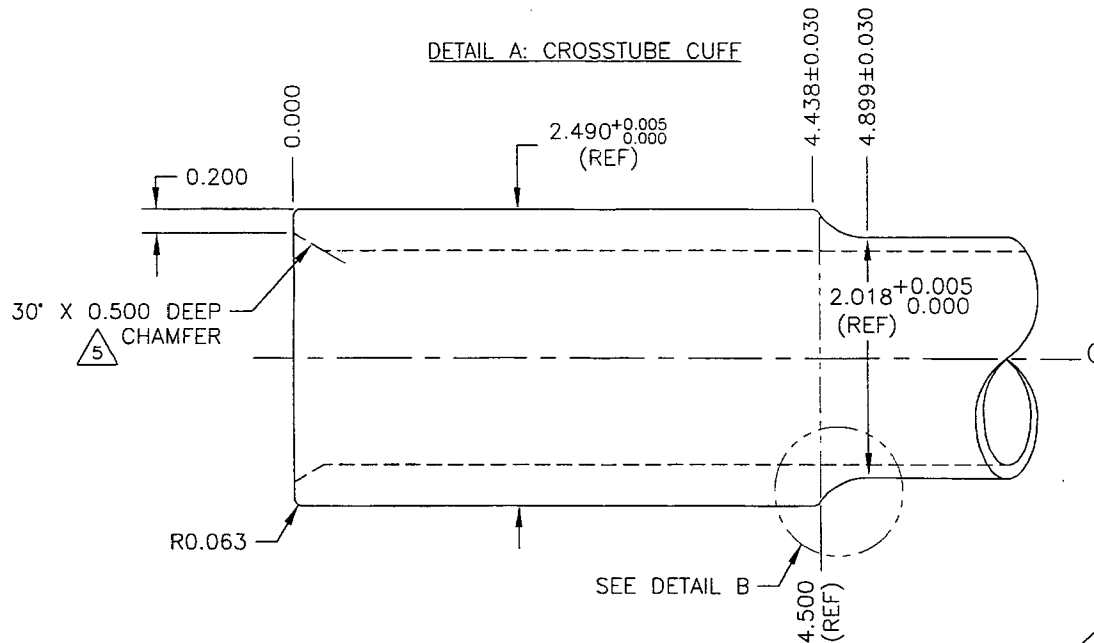
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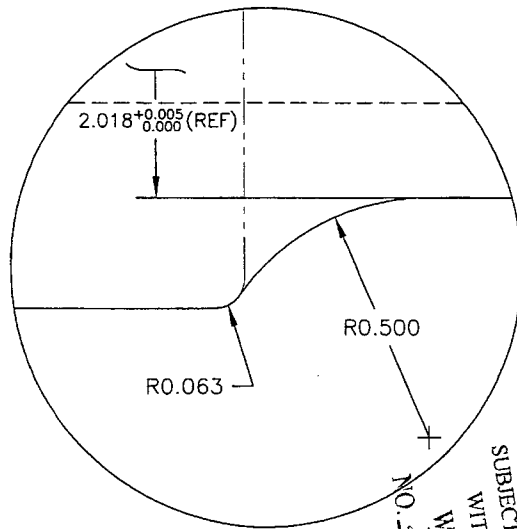
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA	REV. B
CHECKED DS	APPROVED DS	DRAWING NO. D206-667-243	SHEET 2 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:10	

NO. 36059
WORK ORDER
SUBJECT TO AMENDMENT
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RETURN TO
SHOP COPY

DETAIL A: CROSSTUBE CUFF

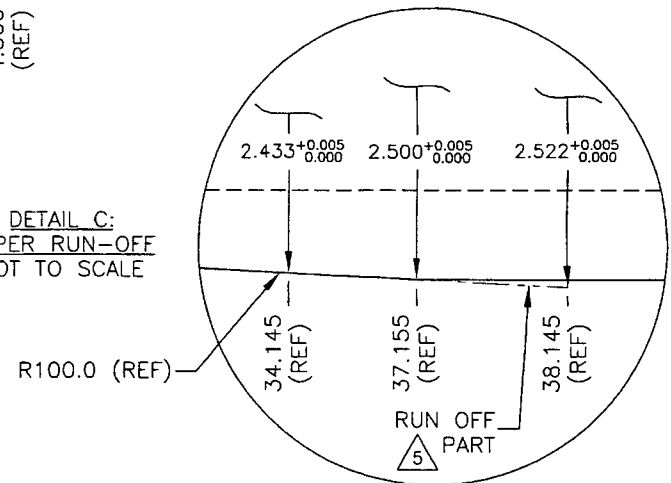


05.07.26 #
UNDER REVIEW
 06.03.26 PH
 Re-drawn detail r
 PH 07.05.02



DETAIL B: CUFF
 TRANSITION
 SCALE 4:1

DETAIL C:
 TAPER RUN-OFF
 NOT TO SCALE



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DATE 05.07.26		CHECKED DS	APPROVED DS	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:1

**ACUREN****LIQUID PENETRANT TEST REPORT****P - 7-1055**PAGE 1 OF 1
TIME AM ☐ PM ☐

CLIENT	DART AREOSPACE	DATE	DEC. 14, 2007
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188-7-01055
ADDRESS	1270 ABERDEEN ST. HAWKESBURY ONT.	PO/NO.	
		WORK LOCATION	HAWKESBURY
		ACCEPTANCE STD.	ASTM 1417/QSI-038
		REV./DATE	2005
PROJECT	212/205 HIGH FED X-TUBE, 206L FWD X-TUBES, 206BAFT X-TUBES, 206L AFT X-TUBES		
ITEM(S) EXAMINED	JOB #'S 35725, 35893, 36051, 36053, 36055, 36056, 36057, 36059,		

JOB DESCRIPTION	PROCEDURE NO. LT-0002	REV./DATE	TECHNIQUE NO. LT-0002-02	REV./DATE
Part No.	D206667201, D206667203, D212664101, D206667103	Material	ALODYNED ALUMINUM	Thickness
Scope	WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE.			

TEST DETAILS

Method	<input checked="" type="checkbox"/> Fluorescent	<input type="checkbox"/> Visible	<input checked="" type="checkbox"/> Water Wash	<input type="checkbox"/> Solvent Removable	<input type="checkbox"/> Post Emulsified
Family Brand	MAGNAFLUX		Black Light S/N	8178	<input checked="" type="checkbox"/> Output > 1000 μ W/cm ²
Penetrant	ZL67	Minimum Dwell time	45	Min.	<input checked="" type="checkbox"/> Ambient < 2 fc
Penetrant Remover	H20	Minimum Dry time	>10	Min.	<input checked="" type="checkbox"/> Output > 100 fc @ surface
Developer	SKDS2	Minimum Dwell time	10	Min.	Other
Developer Type	<input checked="" type="checkbox"/> Non Aqueous	<input type="checkbox"/> Aqueous	<input type="checkbox"/> Dry	Light Meter S/N	Cal Due Date
					MAR 08

TEST SURFACE

Surface Condition	<input checked="" type="checkbox"/> As Ground	<input type="checkbox"/> As Welded	<input checked="" type="checkbox"/> Machined	<input type="checkbox"/> Shot Blasted	<input type="checkbox"/> Clean Bare Metal
Surface Temperature	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F to 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F to 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☐ IMPERIAL)

item	Comments	Accept	Reject
	F.L.P.I. CARRIED OUT ON 100% OF		
	EXTERNAL SURFACE OF: 212/205 HIGH		
	FED X-TUBES JOB# 35893		
	206B AFT X-TUBES JOB #'S 36051, 35725		
	206L FWD X-TUBES JOB#'S 36053, 36055		
	206L AFT X-TUBES JOB #'S 36057, 36059, 36056		
	RESULTS: 206B AFT X-TUBE #36051 HAS ROUGH		
	GRINDING MARKS. TO BE POLISHED AND RECHECKED		
	AT A LATER DATE.		
	ALL OTHER JOB #'S ARE ACCEPTABLE TO ASTM 1417/		
	QSI-038 STANDARD.		

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

Client Representative		DTR #
Technician (Signature):		Report Reviewed by:
Name (Print):	FREDERICK CHAGNON	Name initials
	1 st technician	
CGSB Level	II	CGSB Level
CGSB Reg. No	10560	CGSB Reg. No
	2 nd technician	
	BRENDON MIRAN	
	CGSB Level	II
	CGSB Reg. No	12247

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GOLD - OFFICE COPY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C

REF. CANADIAN STC: SH01-5

REF. FAA STC: SR01304NY

REFERENCE ONLY

THE FOLLOWING D206-667-101/-103/-203 AND D407-667-105 CROSSTUBES HAVE EXTRA HOLES DRILLED ON THE AFT SIDE OF THE CUFFS. THIS HOLE IS NOT REQUIRED FOR INSTALLATION OF DART CROSSTUBES ONTO BHT/AAI SKIDTUBES AS SHOWN IN FIGURE 1.

CUSTOMERS RECEIVING CROSSTUBES AT CHG 002 PRIOR TO 06.08.08 SHOULD CONTACT DART FOR DISPOSITION IF INSTALLING THE DART CROSSTUBES ONTO BHT/AAI SKIDTUBES PER IIN-D206-667 REV. C.

CUSTOMERS RECEIVING CROSSTUBES AT CHG 002 PRIOR TO 06.08.08 TO BE INSTALLED WITH DART SKIDTUBES MAY FIND THAT THE SUPPORTS HAVE BEEN INSTALLED BACKWARDS. THE SUPPORTS SHOULD BE REMOVED AND RE-INSTALLED PER ICA-D206-667.

PART NO.	CHANGE NUMBER	BATCH NO
D206-667-101	002	B24244, B28679, B29261
D206-667-103	002	B26702, B26704, B27980, B25606, B25605, B23220, B23219, B23218, B23217, B28682, B28683, B32664, B34139
D206-667-203	002	B27492, B27491, B27981, B25609, B25608, B25006, B24646, B34144
D407-667-105	002	B31553

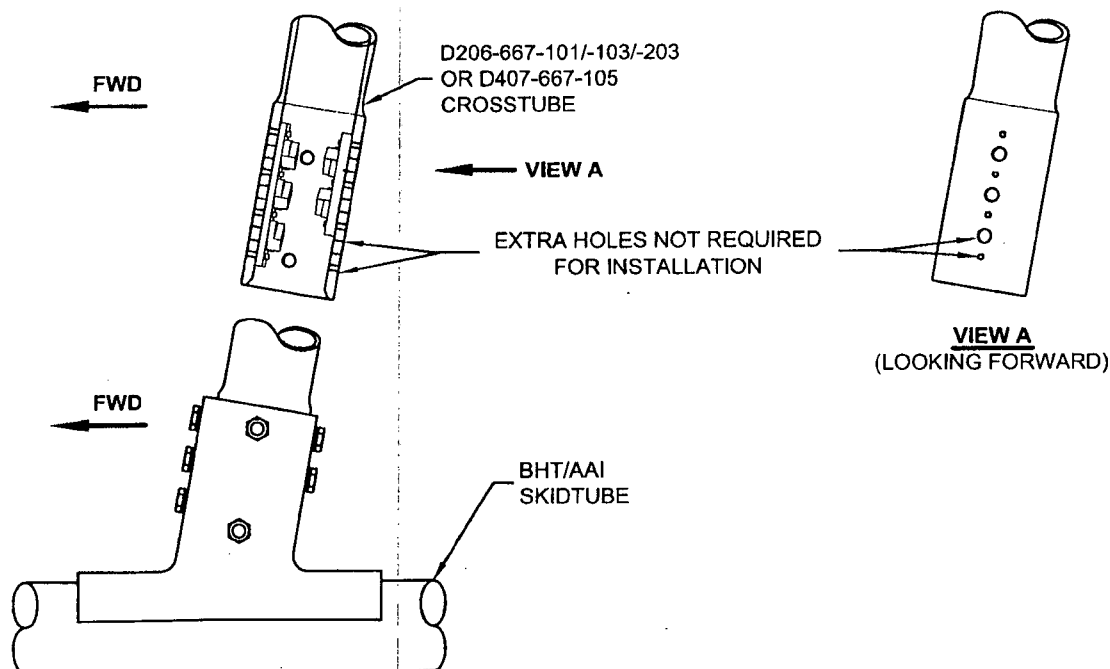


FIGURE 1 - INSTALLATION OF DART CROSSTUBES ON BHT/AAI SKIDTUBE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.10.22
CERT. NO.: SH01-5
ISSUE NO.: 3

F	ADD B34139, B34144	MB	07.10.22
E	ADD D407-667-105 & B31553	MB	07.08.14
D	ADD B32664	MB	07.07.24
C	ADD B29261	MB	06.11.20
B	ADD B28679, B28682, B28683	PH	06.10.10
A	NEW ISSUE	PH	06.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>	DRAWING NO. REV. F DSI 9346 SHEET 1 OF 1	
CHECKED	<i>PH</i>	TITLE SCALE DEVIATION ON D206-667 & D407-667 NTS	
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APPROVED	<i>NO</i>		
DE APPR.	<i>[Signature]</i>		
DATE	07.10.22		

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C

REF. CANADIAN STC: SH01-5

REF. FAA STC: SR01304NY

REFERENCE ONLY

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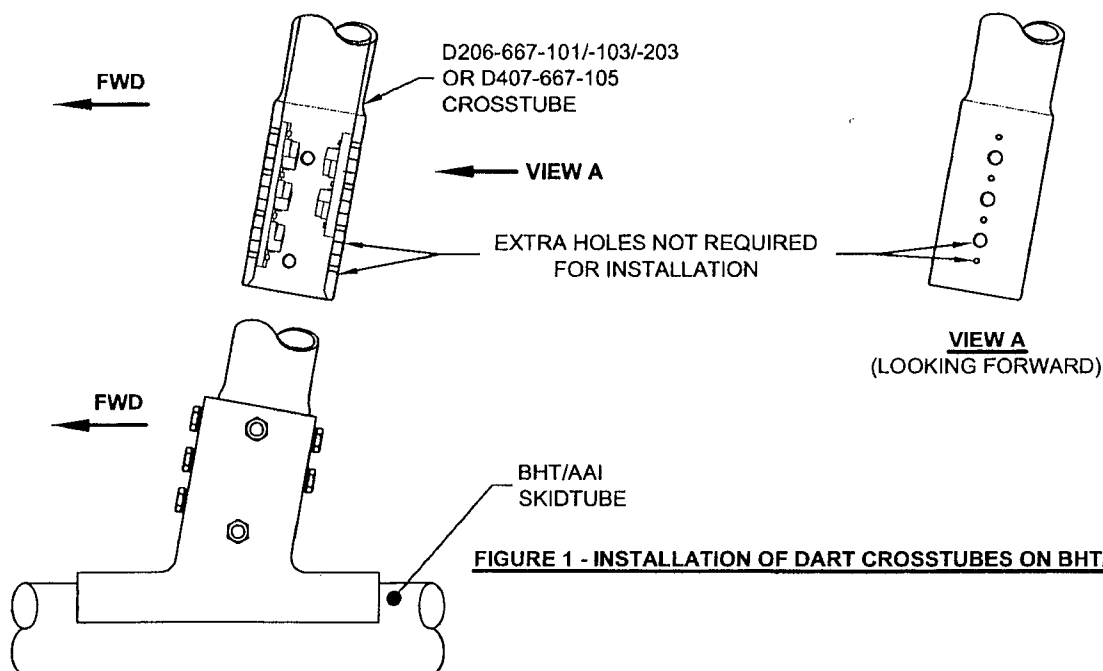


FIGURE 1 - INSTALLATION OF DART CROSSTUBES ON BHT/AAI SKIDTUBE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.01.17

CERT. NO.: SH01-5

ISSUE NO.: 3

G	ADD B36053, B36059	PH	08.01.17
F	ADD B34139, B34144	MB	07.10.22
E	ADD D407-667-105 & B31553	MB	07.08.14
D	ADD B32664	MB	07.07.24
C	ADD B29261	MB	06.11.20
B	ADD B28679, B28682, B28683	PH	06.10.10
A	NEW ISSUE	PH	06.08.08
REV.	DESCRIPTION	BY	DATE

DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>UE</i>	DRAWING NO.	REV. G
MFG. APPR.	N/A	DSI 9346	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DEVIATION ON D206-667 & D407-667	NTS
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